

Sylvie-ASAP

Dart Aerospace Ltd.

Date: Wednesday, 9/12/2007 12:14:19 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 34624	
Estimate Number : 12736	
P.O. Number : <u>N/A</u>	Part Number : D353515
This Issue : 9/12/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 32737	Material : <u>N/A</u>
Written By : _____	Due Date : 9/30/2007 Qty: <u>39</u> Um: Each
Checked & Approved By : <u>07.09.12</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM	
Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.0715 sf(s)/Unit Total : 21.4305 sf(s)
304/316 .040 Sheet
(M304S20GA)
Batch: m165824 IB 07-10-2

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3535 IB 07-10-2
Dwg Rev: B
Prog Rev: B

2-Deburr if necessary IB 07-10-2

(29)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/10/03 (29) contes

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326
2-Form joggle as per Dwg D3535 using Jig DT8158
3-Identify as D3535-15

SB 07/10/03

(29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:14:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 34624

Part Number: D353515

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

En 07/10/03 (222)

7.0

POWDER COATING

POWDER COATING



M104846

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 07-10-04 (X22)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(29X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-p 07/10/04

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(29X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F.P. 15

m-p 07/10/04

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(29)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/10/04

Job Completion



U 07-10-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34624
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	X			
2.000	+/-0.010	2.000	X			
5.650	+/-0.010	5.650	X			
9.150	+/-0.010	9.150	X			
14.400	+/-0.010	14.400	X			
19.650	+/-0.010	19.650	X			
24.900	+/-0.010	24.900	X			
30.150	+/-0.010	30.150	X			
33.650	+/-0.010	33.650	X			
35.650	+/-0.010	35.650	X			
39.150	+/-0.010	39.150	X			
Ø0.188	+0.005/-0.001	.191	X			
24.00	+/-0.030	24.00	X			
16.00	+/-0.030	16.00	X			
8.00	+/-0.030	8.00	X			
5.00	+/-0.030	5.00	X			
0.300	+/-0.010	.302	X			
0.300	+/-0.010	.303	X			
0.038	+/-0.010	.036	X			

Measured by: <i>CB</i>	Audited by: <i>En</i>	Prototype Approval:	N/A
Date: 07-10-2	Date: <i>11/03</i>	Date:	N/A

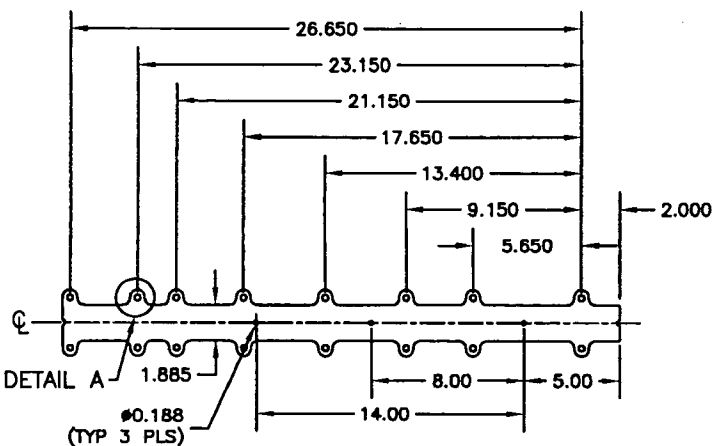
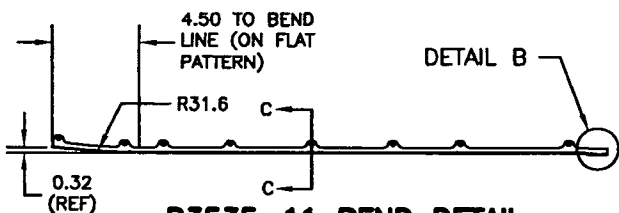
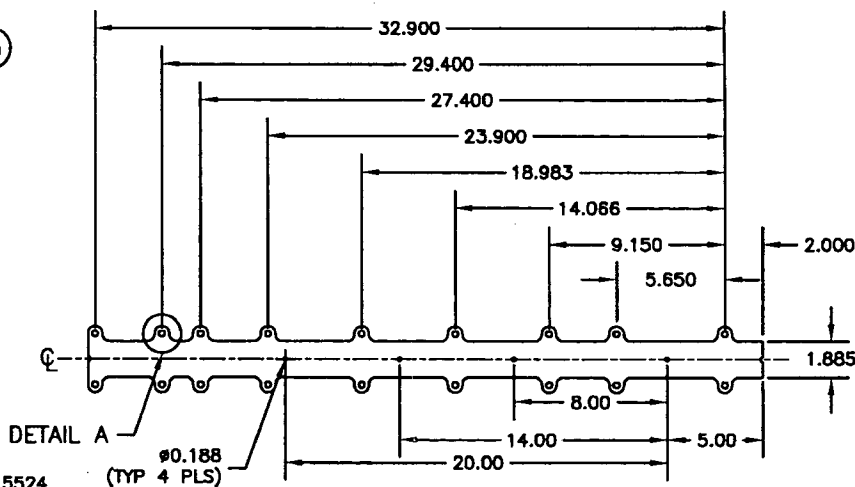
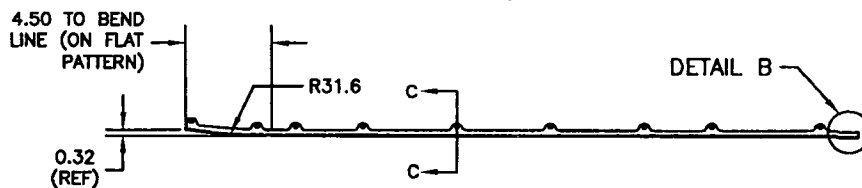
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>AK</i>	<i>BE</i>

DART

RELEASED

07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 1 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

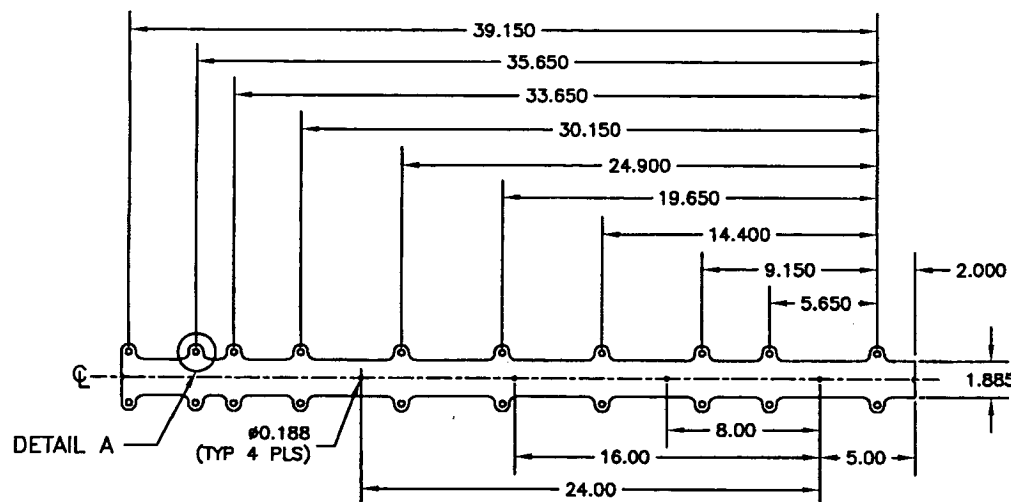
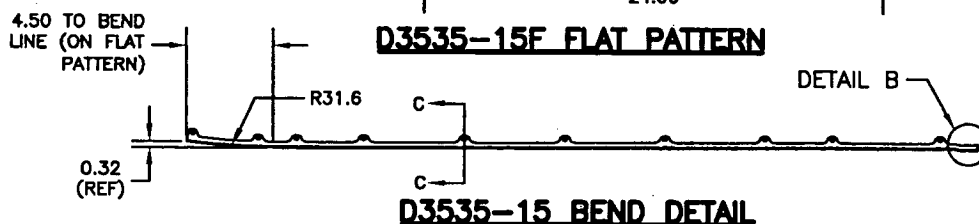
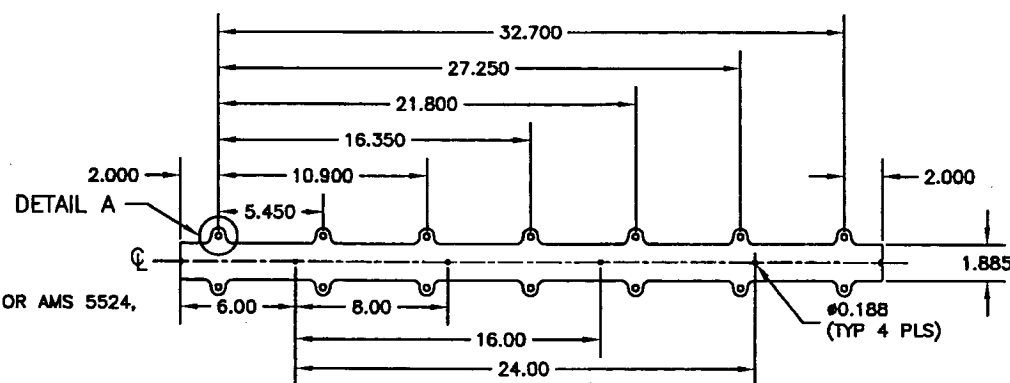
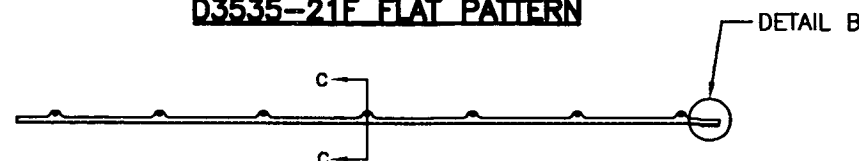
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		D3535	SHEET 2 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

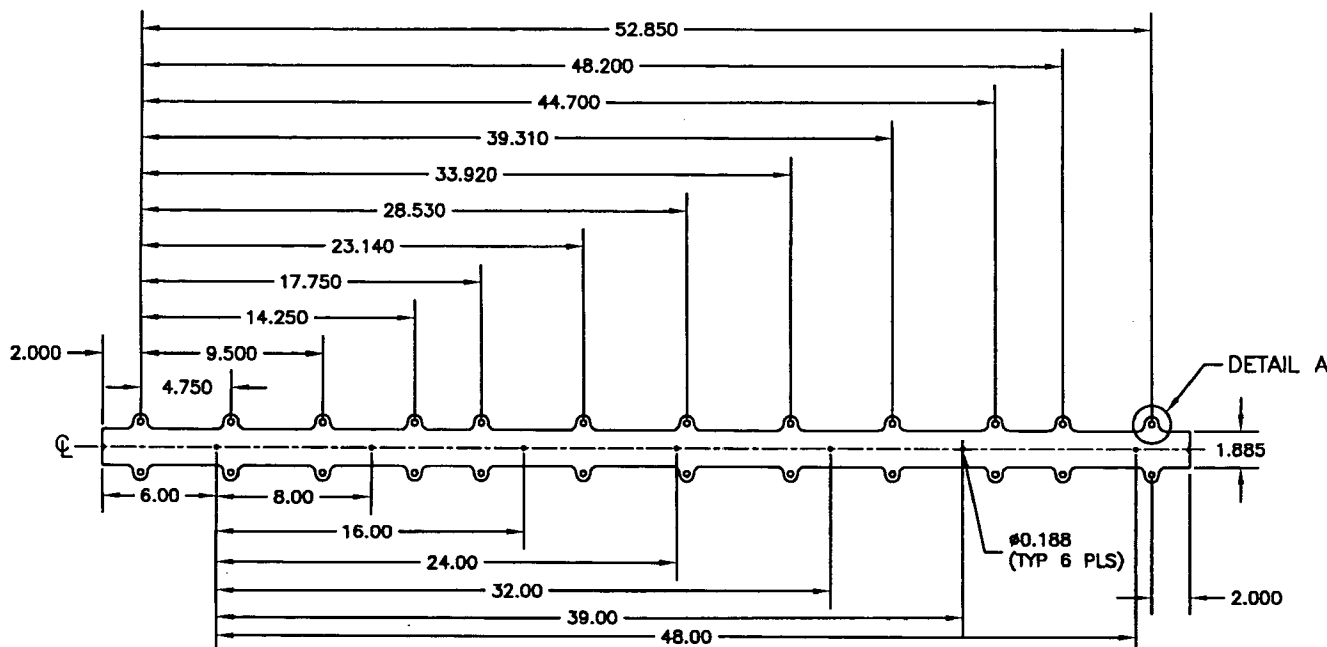
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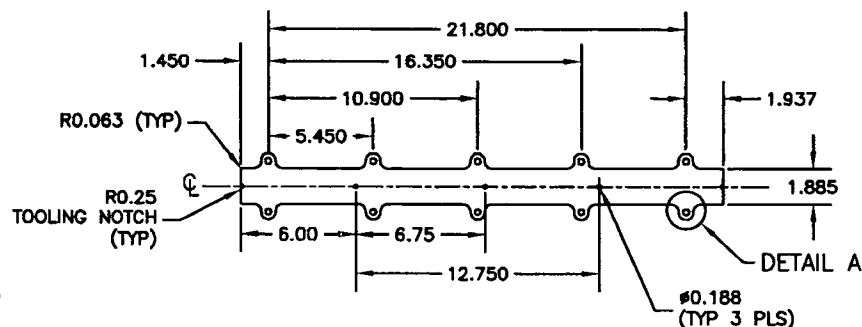
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		TITLE	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	



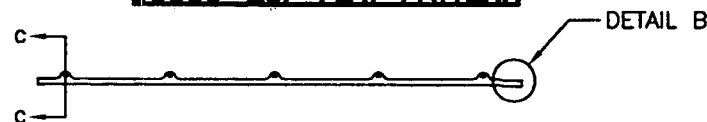
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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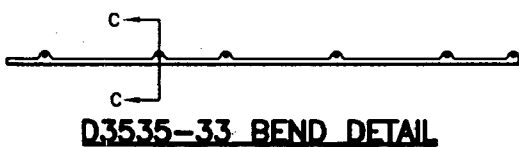
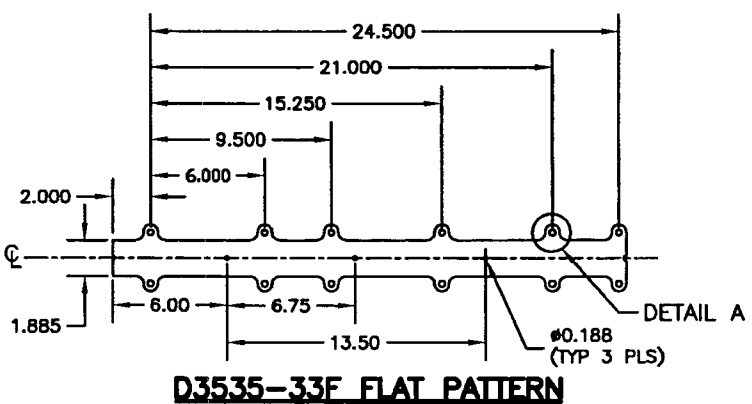
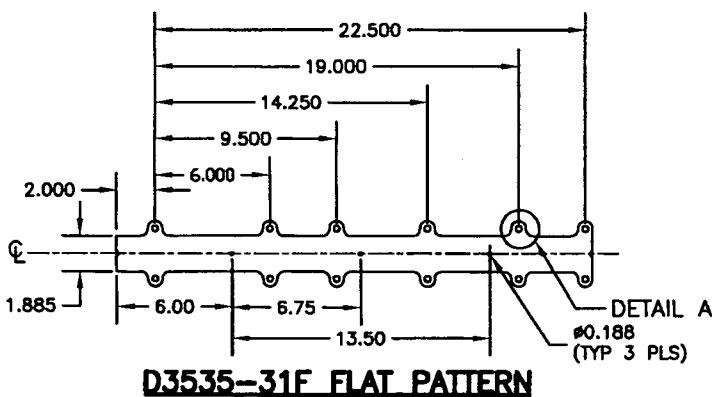
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		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	



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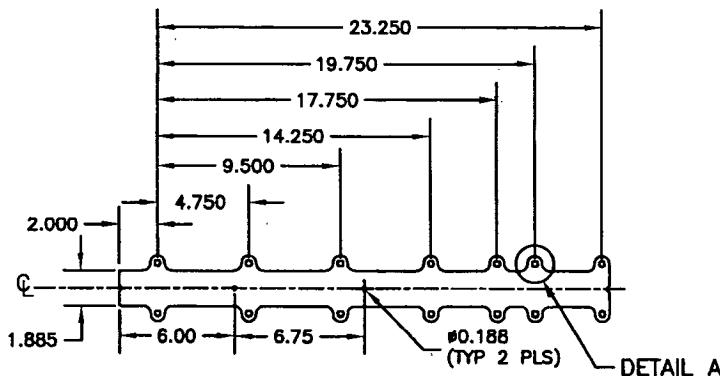
NOTES

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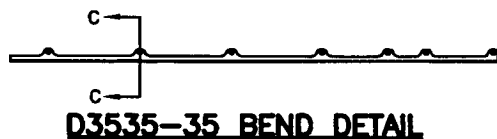
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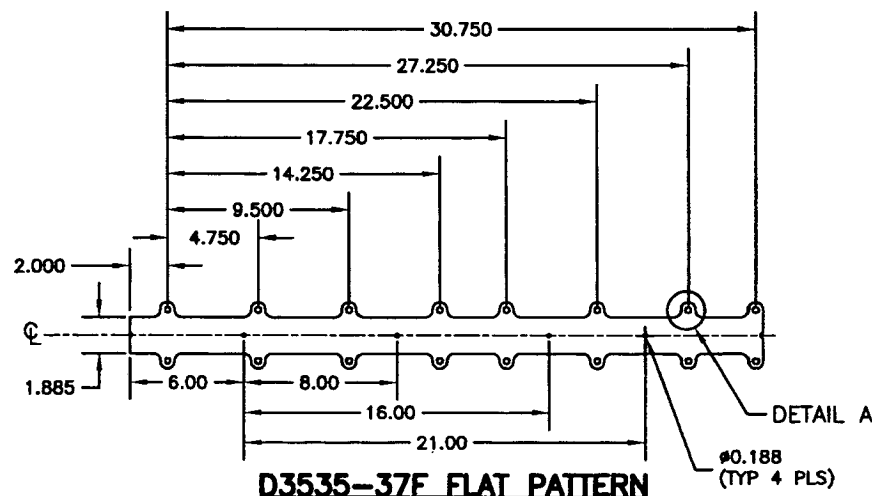
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DATE	07.04.17	TITLE	WEARSHOE	REV. B SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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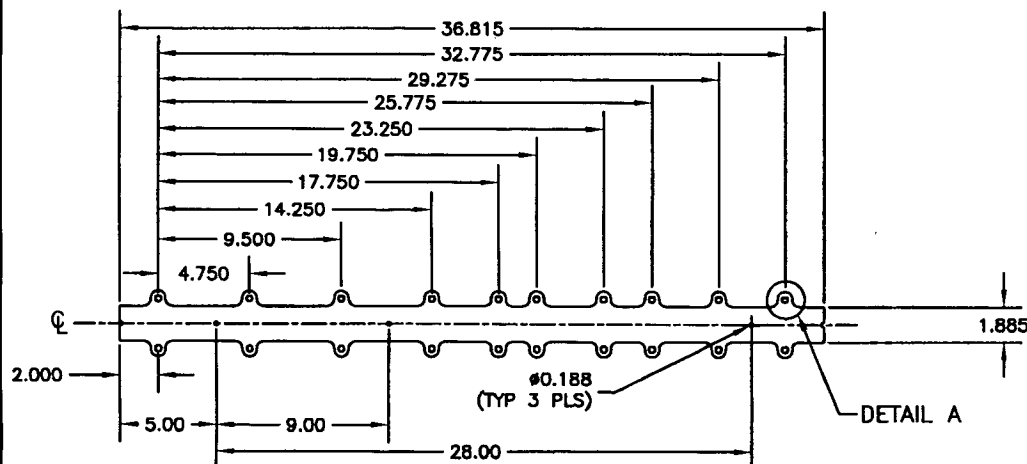
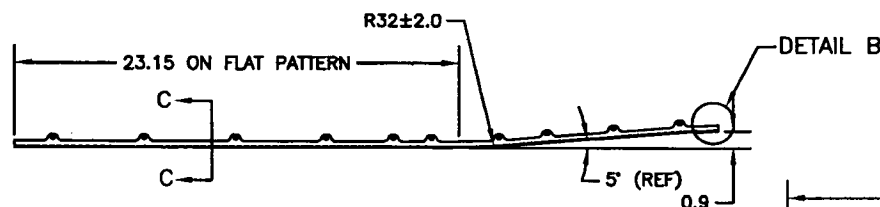
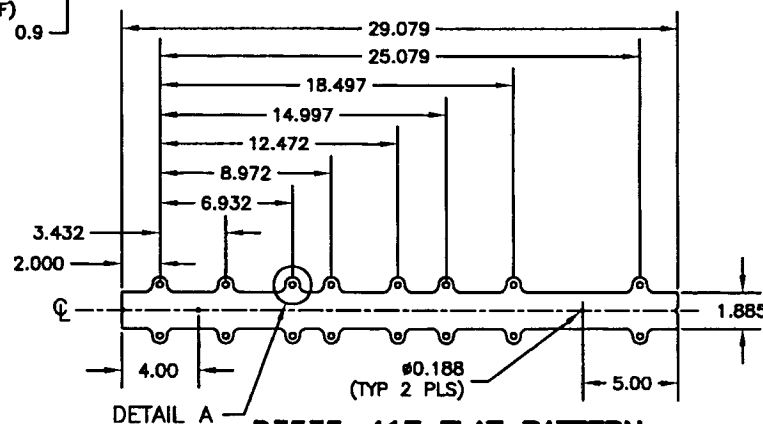
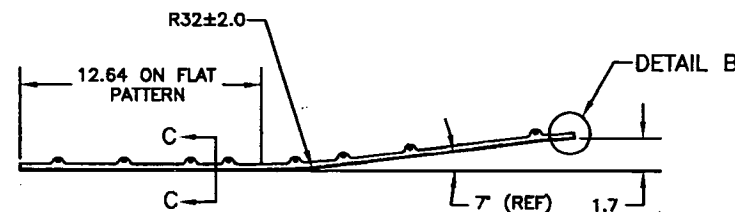
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		D3535	SHEET 6 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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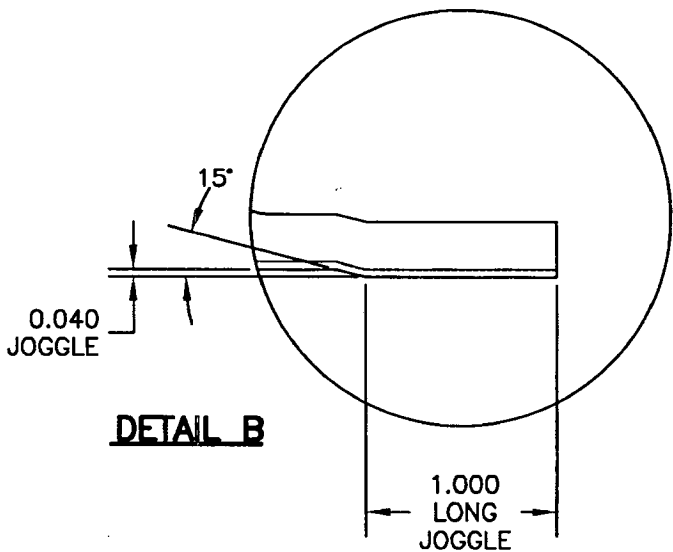
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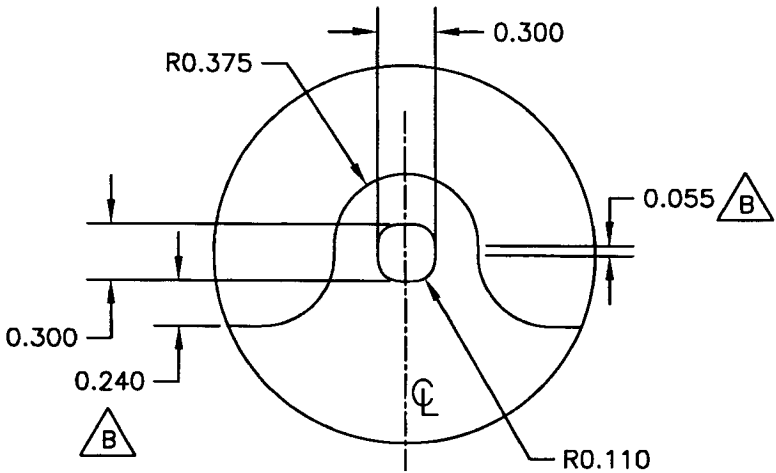
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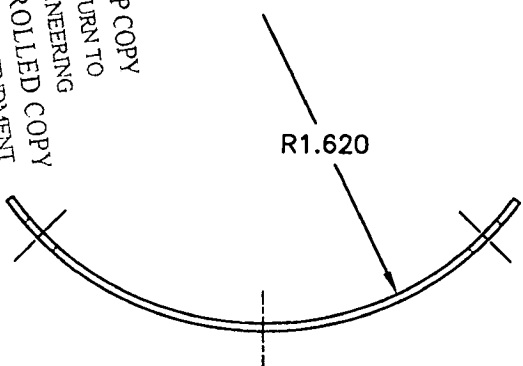
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DETAIL B



DETAIL A



SECTION C-C

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